

Work Order ID 55527

January 19, 2010 3:45:19 PM



Page 1

Item ID: D3298-005

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube Assembly

Start Date: 1/19/10 Start Qty: 6.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *PH*

Date: 10-1-19

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3298

Rev A2

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Bend tube as per template D3298-005T1 & Dwg D3298.1. Flare end as per Dwg D3298.1. Ensure that sleeves and coupling are installed first

=> m, l 10/01/25

(6X)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 8 w/ 1/27

(46)

120

Identify as per dwg & Stock Location: *195*

0.00



Packaging

Memo

0.00

Packaging

10-1-27

(6X) SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55527

Page 2

January 19, 2010 3:45:19 PM

Item ID: D3298-005

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube Assembly

Start Date: 1/19/10 Start Qty: 6.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/28 JG

mr 10-1-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 19, 2010 3:45:24 PM

Page 1

Work Order ID: 55527

Parent Item: D3298-005

Parent Item Name: Tube Assembly


Comments: IPP A: 04.09.02 New issue...KJ/JLM

Start Date: 1/19/10

Required Date: 1/25/10

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN818-6D		Purchased	No			100	Each	42.0000	12.0000			
												
Nut												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 42

103154 2

107756 4

112082 36

M6061T6T0.375W.035 Purchased No

100 f 281.9173 12.1048



6061-T6 RD Tube .375 x.035W

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT 281.9173149

104913 77.9173149

112652 204

MS20819-6D Purchased No

100 Each 42.0000 12.0000



Sleeve

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 42

112082 42

12 X M-L 10/01/25

12.1048 M-L 10/01/25

12 X M-L 10/01/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY	P/N	DESCRIPTION
1	X	D3298-001	TUBE ASSEMBLY
2	2	MS20819-6D	SLEEVE
3	2	AN818-6D	NUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55527
10-1-19

RELEASED
2010-01-14
[Signature]

D3298-001 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.375 O.D. x 0.035 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.375W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-001" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D3298-001T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10) ENSURE SEAMLESS TUBING IS USED

B	DRAWING UPDATED TO CURRENT STANDARDS. 16.00 WAS 15.75 (ZN C3-1, C4-2) & CORRECT VIEW (ZN D4-2). PER CAR 09-004	RF	09.12.30
A	NEW ISSUE	RF	04.07.05
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3298	SHEET 1 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TUBE ASSEMBLIES	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

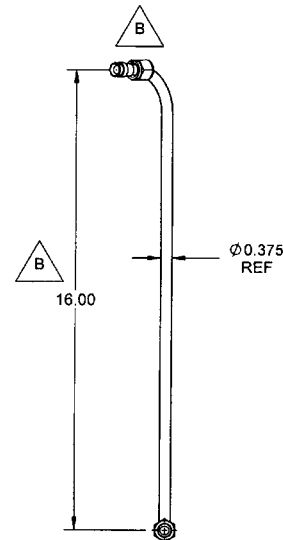
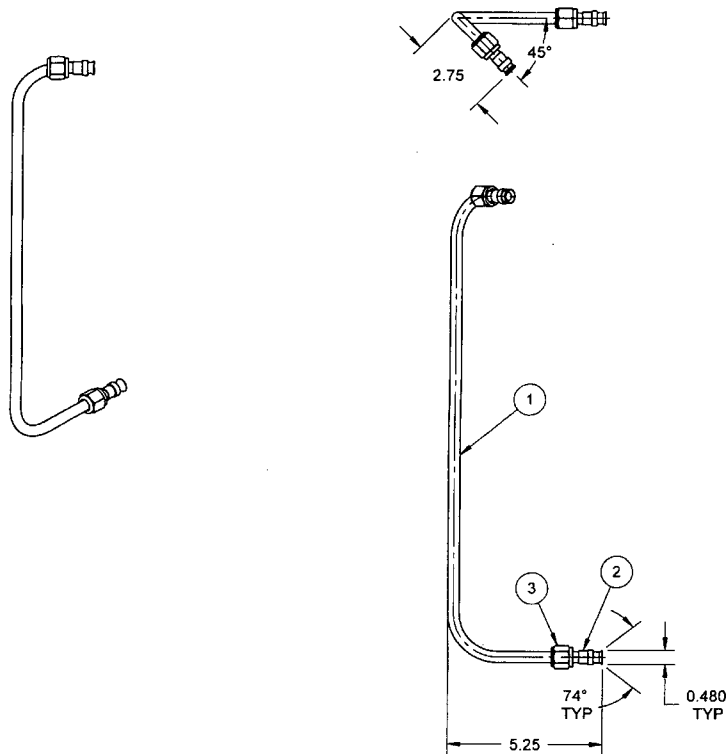
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -003	P/N	DESCRIPTION
1	X	D3298-003	TUBE ASSEMBLY
2	2	MS20819-6D	SLEEVE
3	2	AN818-6D	NUT



D3298-003 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.375 O.D. x 0.035 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.375W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-003" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D3298-003T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10) ENSURE SEAMLESS TUBING IS USED

RELEASED
2010-01-14
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DRAWN	RF		
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MFG. APPR.	<i>RF</i>	D3298	SHEET 2 OF 8
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	TUBE ASSEMBLIES	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

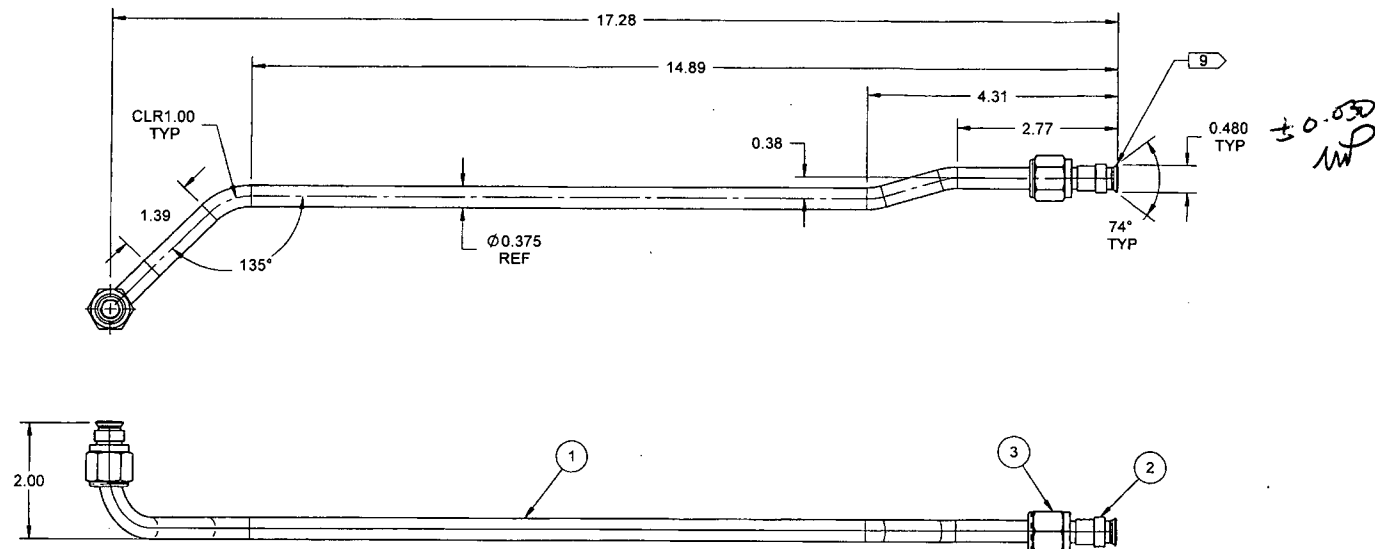
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
1	X	D3298-005	TUBE ASSEMBLY
2	2	MS20819-6D	SLEEVE
3	2	AN818-6D	NUT



D3298-005 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.375 O.D. x 0.035 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.375W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-005" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D3298-005T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10) ENSURE SEAMLESS TUBING IS USED

RELEASED
2010-01-14
WLO

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3298	SHEET 3 OF 8
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DE APPR.	RF	TUBE ASSEMBLIES	NTS
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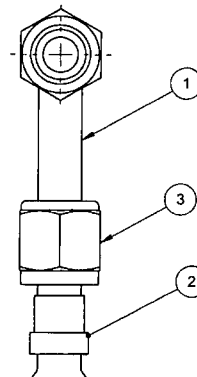
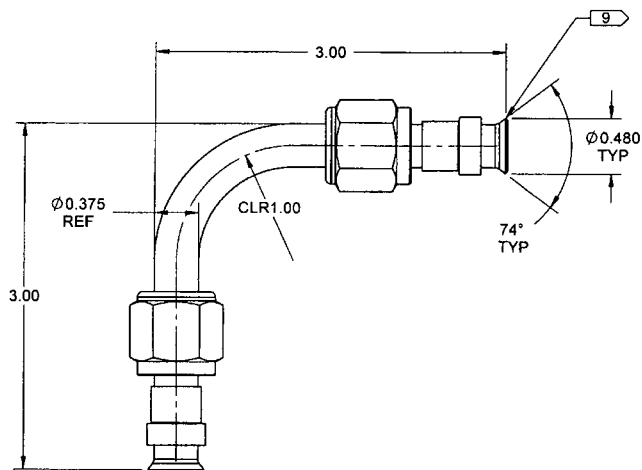
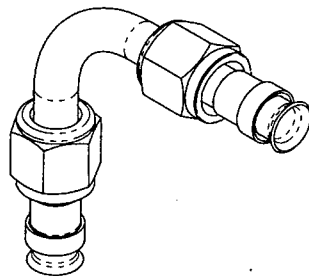
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ITEM	QTY -007	P/N	DESCRIPTION
1	X	D3298-007	TUBE ASSEMBLY
2	2	MS20819-6D	SLEEVE
3	2	AN818-6D	NUT

D3298-007 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.375 O.D. x 0.035 WALL
PER WWV-T-700/6
REF DART SPEC M6061T60.375W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-007" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.05 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D3298-007T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10 ENSURE SEAMLESS TUBING IS USED

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2010-01-14

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DRAWN	RF		
CHECKED	AB	DRAWING NO.	REV. B
MFG. APPR.	FE	D3298	SHEET 4 OF 8
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DE APPR.	14	TUBE ASSEMBLIES	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

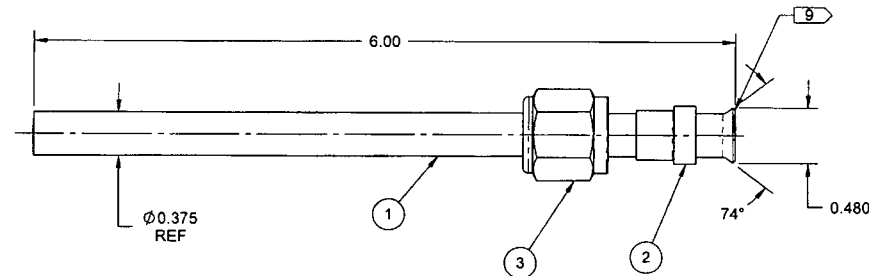
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -009	P/N	DESCRIPTION
1	X	D3298-009	TUBE ASSEMBLY
2	1	MS20819-6D	SLEEVE
3	1	AN818-6D	NUT



D3298-009 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.375 O.D. x 0.035 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.375W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-009" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.04 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D3298-009T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS
- 10) ENSURE SEAMLESS TUBING IS USED

RELEASED
2010-01-16

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3298	SHEET 5 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	TUBE ASSEMBLIES	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

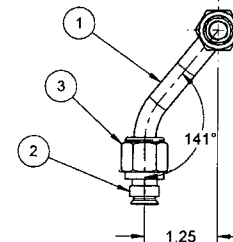
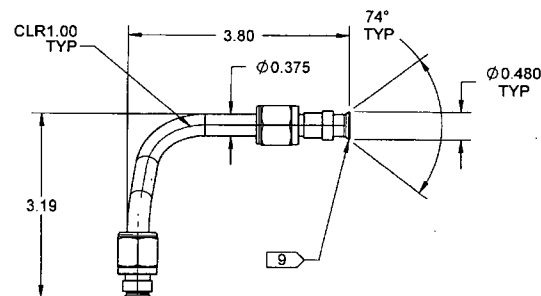
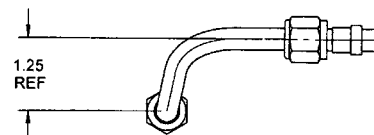
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY .011	P/N	DESCRIPTION
1	X	D3298-011	TUBE ASSEMBLY
2	2	MS20819-6D	SLEEVE
3	2	AN818-6D	NUT



D3298-011 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.375 O.D. x 0.035 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.375W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-011" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D3298-011T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10 ENSURE SEAMLESS TUBING IS USED

RELEASED
2010-01-14

DESIGN	RF	DART AEROSPACE LTD	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3298	SHEET 6 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TUBE ASSEMBLIES	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

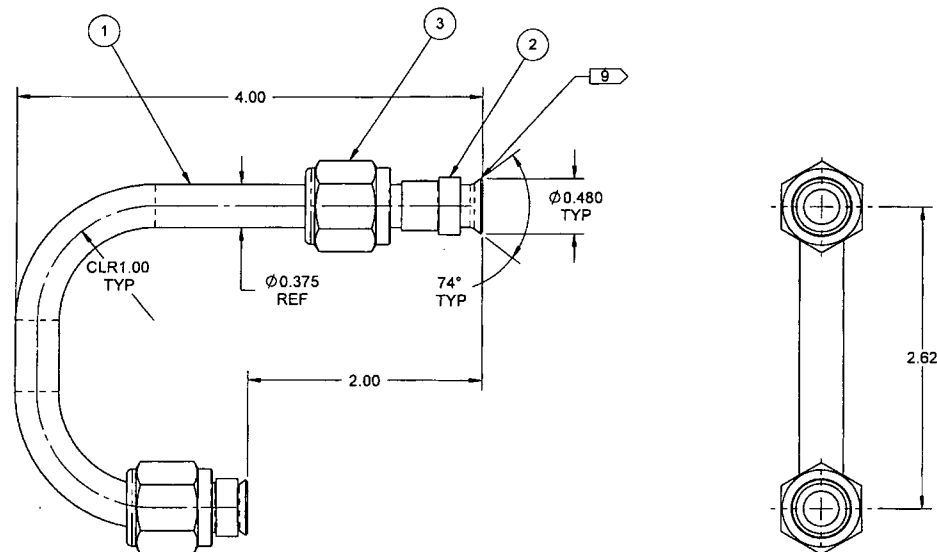
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY .013	P/N	DESCRIPTION
1	X	D3298-013	TUBE ASSEMBLY
2	2	MS20819-6D	SLEEVE
3	2	AN818-6D	NUT



D3298-013 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.375 O.D. x 0.035 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.375W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-013" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D3298-013T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10 ENSURE SEAMLESS TUBING IS USED

RELEASED
2018-01-24

W/0 55522

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO. D3298	REV. B
MFG. APPR.	<i>RF</i>		SHEET 7 OF 8
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	TUBE ASSEMBLIES	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

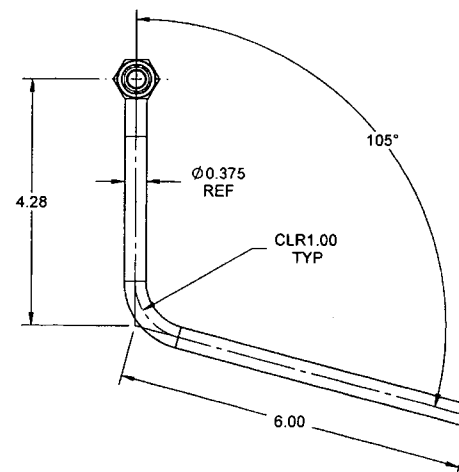
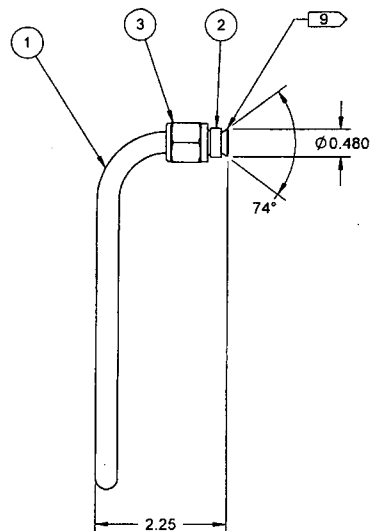
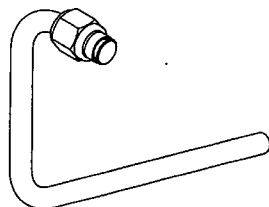
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
1	X	D3298-015	TUBE ASSEMBLY
2	1	MS20819-6D	SLEEVE
3	1	AN818-6D	NUT



D3298-015 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.375 O.D. x 0.035 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.375W.035
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-015" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D3298-015T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS
- 10 ENSURE SEAMLESS TUBING IS USED

RELEASED
2018-01-14

W/O 55527

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3298	SHEET 8 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	TUBE ASSEMBLIES	NTS
DATE	09.12.30	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries